

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72401

Monday, July 25, 2011 9:23:00 AM



Page 2

Item ID: D3578-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/25/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

I-Open rivet holes to 0.098" and C'sink as per dwg D3578

Handwritten: 11/08/15 (30)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Handwritten: counts x30 11/08/15

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

Handwritten: 30 of 11/08/15

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Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/25/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

30 X 2 M-11/08/15

170



Small Fab

Small Fab

Small Fab

Memo

1-Assemble as per dwg D3578

0.00

0.00

9/5/08/16 (30)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Suloch

counts
(x30)

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Work Order ID 72401

Monday, July 25, 2011 9:23:00 AM



Page 4

Item ID: D3578-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/25/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>245A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/8/17 (30) f

11/8/18 J

11-08-18 (30)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, July 25, 2011 9:23:10 AM

Page 1

Work Order ID: 72401

Parent Item: D3578-041

Parent Item Name: Doubler



Start Date: 7/25/2011

Required Date: 9/5/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: A ☐ 07.04.11 ☐ New issue ☐ EC ☐
IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 Rivet		Purchased	No			110	Each	1,963.000	2	40			
<div>Location</div> <div>ST316</div> <div>19099</div>													
<div>Loc Qty</div> <div>1963</div> <div>1963</div>													
<div>Loc Code</div> <div></div> <div></div>													
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			170	sf	219.9000	0.007	0.147368			
<div>Location</div> <div>MAT021</div> <div>116268</div> <div>117285</div>													
<div>Loc Qty</div> <div>219.9</div> <div>17.5</div> <div>202.4</div>													
<div>Loc Code</div> <div></div> <div></div> <div></div>													
MS21075L3 Nutplate		Purchased	No			170	Each	158.0000	1	20			
<div>Location</div> <div>ST303</div> <div>117677</div>													
<div>Loc Qty</div> <div>158</div> <div>158</div>													
<div>Loc Code</div> <div></div> <div></div>													

40

60

B11-8-11

1.

30

117285

11/8/11

30

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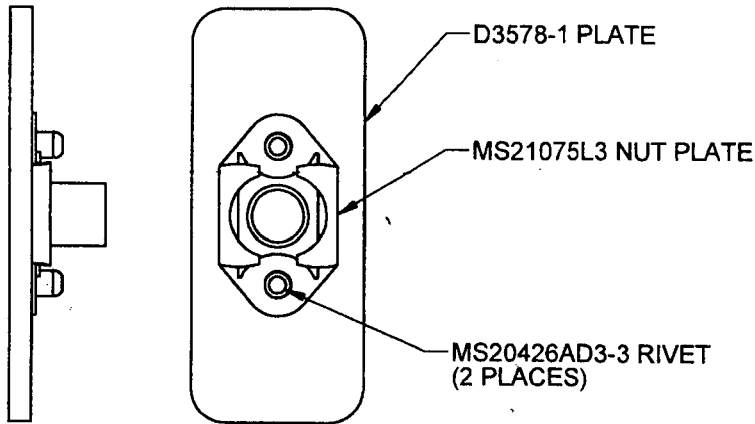
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

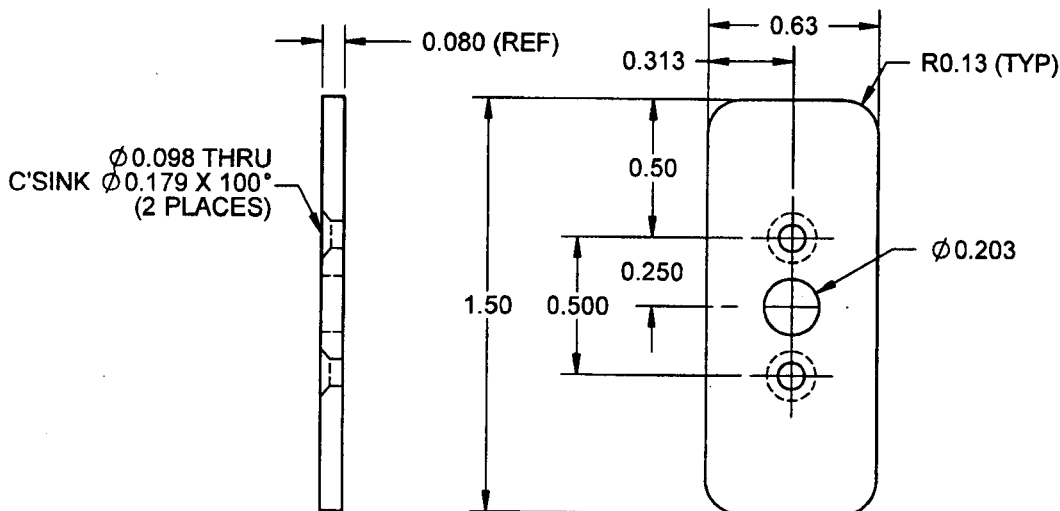
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JS</i>	APPROVED <i>JS</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12	TITLE DOUBLER		SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

**RELEASED**
07.04.02**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER**D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72401**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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